



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3913-041
Job Sheet 179316



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/31/18	0.00	0.00	Start Up Large Fab-5		2018-06-26
100	Large Fab	1 pcs		7/31/18	0.00	10.00	Large Fab 1		2018-07-12
110	QC	1 pcs		7/31/18	0.00	0.00	QC9		
120	QC	1 pcs		7/31/18	0.00	0.00	QC5		
125	HandFinish	1 pcs		7/31/18	0.00	0.29	HandFinish2		2018-07-19
130	Powdercoat	1 pcs		7/31/18	0.00	0.93	Powdercoat2		2018-07-19
135	Packaging	1 pcs		7/31/18	0.00	0.00	Packaging1		2018-07-19
140	QC	1 pcs		7/31/18	0.00	0.00	QC3		2018-07-19
150	HandFinish	1 pcs		7/31/18	0.00	0.50	HandFinish4		2018-07-19
160	QC	1 pcs		7/31/18	0.00	0.00	QC5		2018-07-19
170	Packaging	1 pcs		7/31/18	0.00	0.00	Packaging3-2		2018-07-19
180	QC21-SA	1 Ea		7/31/18	0.00	0.00	QC21		JUL 20 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138839 START: 9:30 OUT: 375° FINISH: 9:45

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5068733
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5082948
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5068414
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5080994
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5079285
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5066247
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5080509
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5084063
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5079862
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5068796
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5067578
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5071126

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5070373② 506816④
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	508306416
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5080939
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5054936
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5070544
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5078251
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5076007-1
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5078253
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5071414
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5067452

Job Allocations

004528

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	75	0
	D3913-1	1	2	0
	D3913-15	1	12	0
	D3913-3	1	13	0
	D3913-7	2	24	0
	D3913-9	1	6	0
	D3916-041	2	14	0
	D3916-5	3	13	0
	D4016-1	3	25	0
	D4017-7	3	57	0
	D4017-9	2	12	0
	D4020-11	2	13	0
	D4021-1	3	52	0
	D4034-041	1	4	0
	D4034-043	1	5	0
	D4672-1	2	22	0
	M304EX0.75-16F	33	1,310	0
150-HandFinish	AN3-10A	6	180	0
	D2931	2	1,018	0
	D4021-5	2	40	0
	MS20600-AD4W3	2	405	0
	MS21042L3	6	1,544	0
	NAS1149F0332P	12	1,710	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER I

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework Scrap Use-as-is Suspected Unapproved
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

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QC / QA Coordinator
Approval

Root Cause				FAULT CATEGORY						
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

DCART
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 692-5200
Email: sales@dcart.com
www.dcartospace.com

Part: D3913-041
Job No: 179316
Serial No/Batch: S084276

Revision:
Inspector:
Exp Date:
Instructions:

Date: 06/26/18

Container No: S084276

